

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021199**Date Inspected:** 24-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Mike Johnson		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No
Component:	S.A.S. components	

Bridge No: 34-0006**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI witnessed overhead position (4F) fillet weld soundness tests for a Procedure Qualification Record (PQR) that ABF is planning to use on the Tower Grillage assembly. The welding was performed by Richard Bazewicz, ID 3068, with Shielded Metal Arc Welding (SMAW) and 3.2 mm E9018 H4R electrode. The QAI noted that the Quality Control (QC) Inspector Mike Johnson was monitoring the welding, welding parameters and the preheat/interpass temperatures. The QAI noted that the observed welding appeared to be within conformance of the contract requirements and PQR settings and issued lot number B212-004-11A. The QAI wrote an accompanying TL-6032 report for the test. Reference the TL-6032 report for additional information. The QAI was informed that test plate will be sent to Anamet Inc, for weld testing and that the Engineer will be notified when it is ready for witnessing.

The QAI observed ABF personnel fitting and tack welding cover plates into the Tower Grillage at Pier 7. The QAI noted that the cover plates are 25mm thick and that all the materials to be welded are grade 485W. The QAI was informed that only tack welding is approved at this time and that the welding procedures are still being developed. The QAI noted that the Quality Control (QC) Inspector Mike Johnson is monitoring the tack welding. The QAI noted that Rick Clayborn, ID 2773, is using shielded metal arc welding (SMAW) and localized preheating to make the overhead tack welds. The QAI noted that 3.2mm diameter, E9018-H4R electrodes are being used for the tack welding. The QAI noted that a Request for Information (RFI), # 2373 Revisions 0 and 1 have been approved and relate to the fit-up of the cover plates. The QAI noted that these plates are being removed,

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modified per the approved RFIs and will be re-fit. The QAI noted that the tack welding is not completed and will continue tomorrow, 2.25.2010.

Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift, as noted above. The QAI relayed the status of weld testing and tower grillage welding to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
